

Date: Tuesday, 5/16/2006 10:40:46 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 27143		
Estimate Number	: 11376		
P.O. Number	: N/A	Part Number	: D33872
This Issue	: 5/16/2006 S.O. No. : N/A	Drawing Number	: D3387 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 27105	Material	: N/A
Written By	: <i>See 1st comment below</i>	Due Date	: 5/30/2006
Checked & Approved By	: <i>06.05.16</i>	Qty:	10 Um: Each
Comment	: Est:A 05.06.10 New Issue KJ/JLM : Est:B 06.03.22 Split c'sink op. EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5680 f(s)/Unit Total: 15.6797 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6/T651 (QQ-A-200/8)
 (M6061T6B0.500x06.000)
 Identify for D3387-2
 Batch: *M100817*

ml 06/05/19 16

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 6.000" x 0.500" x 17.800" long

ml 06/05/19 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA512 and Dwg D3387
 Identify as D3387-2
 Tumble and Deburr NO sharp edges

J.F. 06/05/20 10

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 C'sink Ø0.375" as per Dwg D3387..

ml 06/05/24 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *AS* Date: 04/05/25

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/16/2006 10:40:46 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 27143

Part Number: D33872

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/05/25

10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/05/25

10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA28*

LE 06.05.25

10

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

RD 06/05/25

10

Job Completion



C 206/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27143
Description: Arm		Part Number:	D3387-2
Inspection Dwg: D3387		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.502	—			
7.577	+/-0.010	7.578	—			
R0.030	+/-0.010	R0.030	—			
Ø0.191	+0.005/-0.000	Ø0.192	—			
1.700	+/-0.010	1.703	—			
0.188	+/-0.010	0.190	—			
11.405	+/-0.010	11.405	—			
Ø0.507	+0.000/-0.001	Ø0.507	—			
2.033	+/-0.005	2.033	—			
R0.300	+/-0.010	R0.300	—			
1.000	+/-0.005	1.000	—			
2.000	+/-0.010	2.003	—			
1.347	+/-0.005	1.347	—			
0.250	+/-0.010	0.245	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.122	—			
R0.032	+/-0.010	R0.032	—			
Ø0.375 x100°	+/-0.010	Ø0.375x100°	—			
0.500	+/-0.010	0.493	—			
0.300	+/-0.010	0.297	—			

Measured by:	JML	Audited by:	J.F.	Prototype Approval:	N/A
Date:	06/05/19	Date:	06/05/20	Date:	N/A

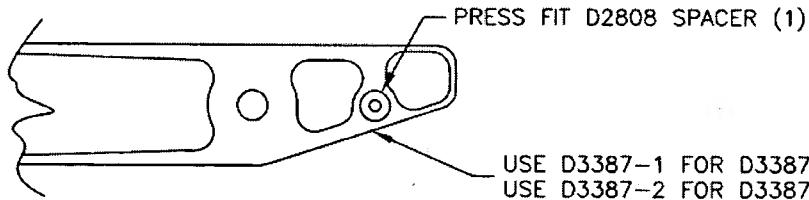
Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	JML

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.01.18	DRAWING NO. D3387	REV. A
	TITLE ARM	SHEET 1 OF 1
A	05.01.18	SCALE 1:3
	NEW ISSUE	

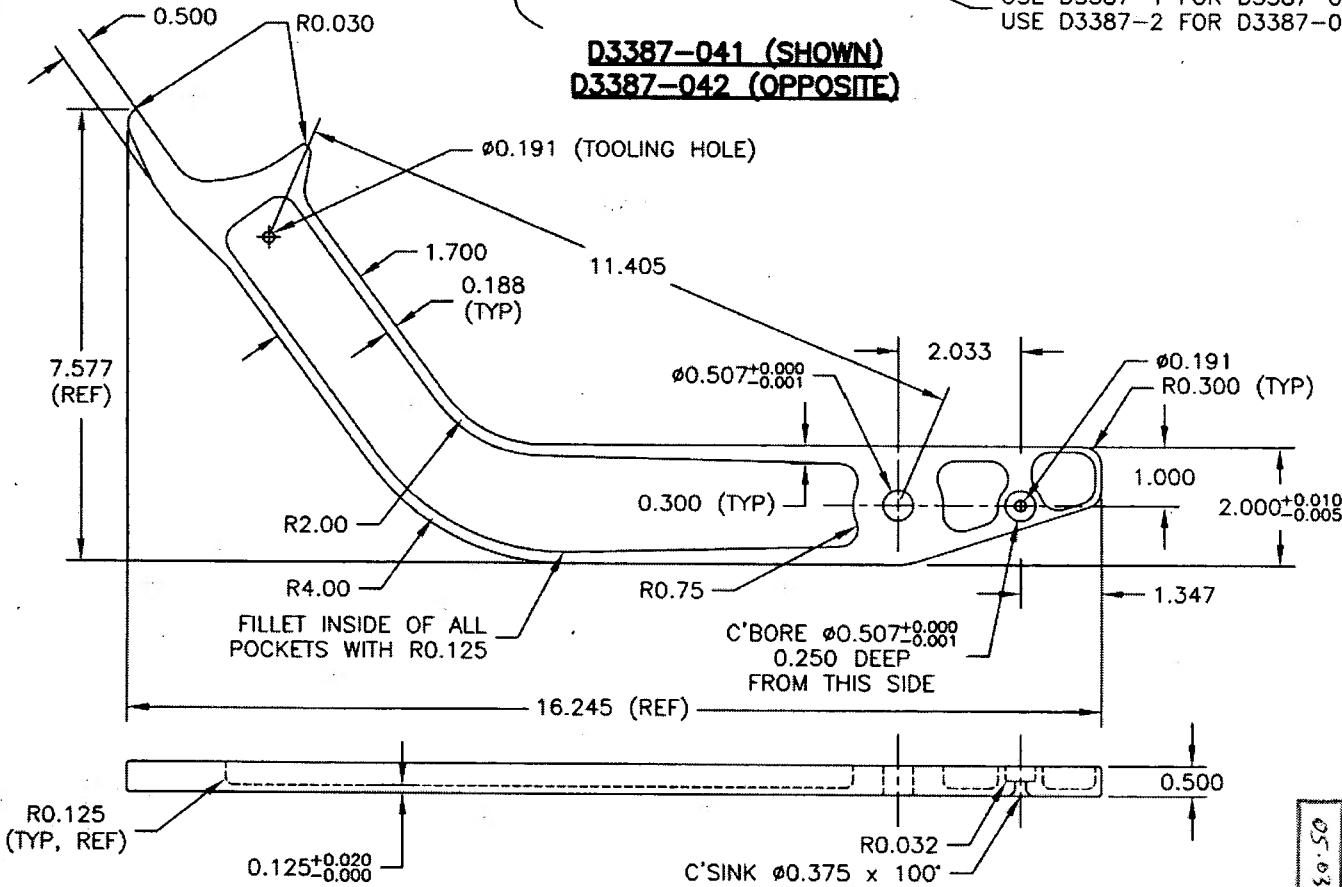
RELEASED

05.03.11



USE D3387-1 FOR D3387-041
USE D3387-2 FOR D3387-042

D3387-041 (SHOWN)
D3387-042 (OPPOSITE)



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

1. MACHINE PER DRAWING FILE "D3387-A.DWG"
2. MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK (REF DART SPEC. M6061T6B0.500)
3. DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 21143

